

Date: Friday, 1/18/2008 9:00:17 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
Job Number : 36849	
Estimate Number : 10258	
P.O. Number :	Part Number : D2332041
This Issue : 1/18/2008 S.O. No. :	Drawing Number : D2332
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/17/2008 Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 35718	Material :
Written By :	Due Date : 2/10/2008 Qty: 20 Um: Each
Checked & Approved By : <u>08 01 18</u>	
Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 K J/Rf	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR1000W049	304 RD Tube 1.0" x .049W
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Comment: Qty.: 0.4331 f(s)/Unit Total : 8.6625 f(s)  
 Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch M105260

2.0	M304R250	1/4" 304 SS Roundbar
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Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s)  
 Material: Ø0.250" 304SS Rod  
 Batch M105260

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Deburr

4.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.2502 f(s)/Unit Total : 25.0040 f(s)  
 304 RD Tube .500 x .035W

M106593FF 08-01-24 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/18/2008 9:00:17 AM  
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Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

FF 08-01-24

20

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly) ✓

A/R SS Rod Batch:

~~M105950~~ H105138

H105138

08/02/04

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-02-04 (20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-02-04 (20)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

08/02/04 (20)  
08/02/07 (20)

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

20

M101291

8/2/08 20x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/18/2008 9:00:17 AM  
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Job Number: 36849

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M106785

SP



12.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

20

M105938

8/2/05 SP (20X)

13.0

QC5

INSPECT:WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/07 (20X)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 203

8/2/08

SP (20X)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/08

Job Completion



min 2008/2/08

(20)

W

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

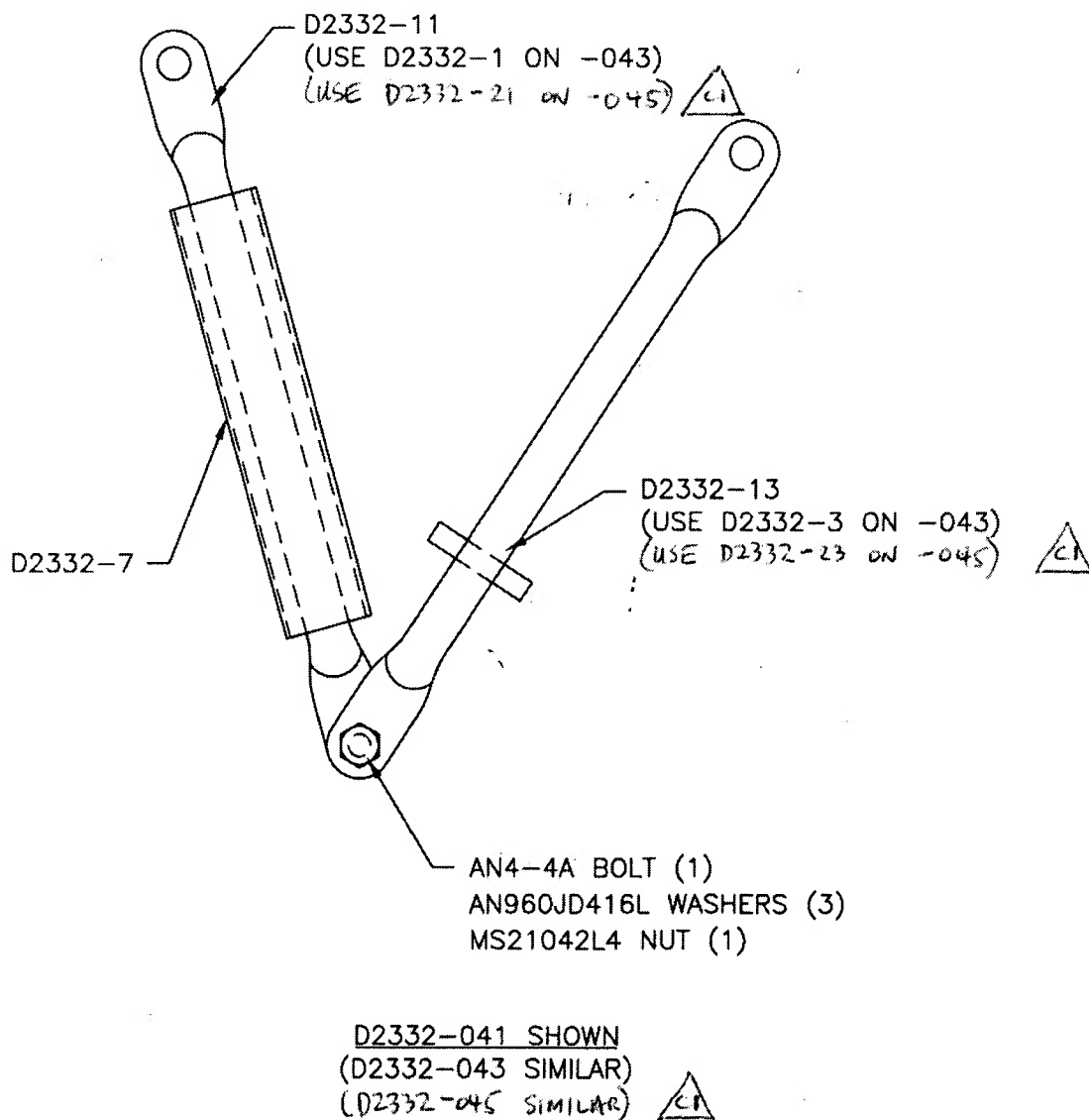
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.35" LONG)	

RELEASED  
03.07.04









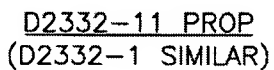
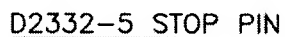
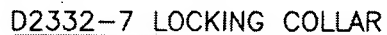
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0208/01/24  
w/o 36849

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DESIGN		DRAWN BY		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. C
CHECKED		APPROVED		DRAWING NO.	D2332	SHEET 2 OF 2
DATE	03.07.03	TITLE		LID PROP ASSEMBLY		
C		03.07.03	MATE -041 PROP 6.64" LONG (57D) MATE -043 PROP 8.00" LONG (107)			
C1		03.08.06	ADD -045 PROP 7.25" LONG			



D2332-13  
M/F D2332-11 & D2332-5  
(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

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